


Date: Wednesday, 5/21/2008 8:59:44 AM  
 User: David Duval

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE ASS'Y, CABIN SLIDING DOOR
Job Number	: 39362		
Estimate Number	: 13332		
P.O. Number	:	Part Number	: D3779043
This Issue	: 5/21/2008 S.O. No. :	Drawing Number	: PROTO
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : R & D SM/MED FAB	Drawing Revision	: PROTO
Previous Run	: 39358	Material	:
Written By	: 	Due Date	: 5/28/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A 08-05-20 new issue DD verified by:ec		

## Additional Product

# PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY FOR ENGINEERING USE ONLY

Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S125	6061-T6 .125 Sheet
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Comment: Qty.: 0.4583 sf(s)/Unit Total : 0.4583 sf(s)

6061-T6 .125 Sheet

batch: 106634 RB 8-5-21

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3779

Dwg Rev: PROTO

Prog Rev: PROTO

RB 8-5-21

①

2-Deburr if necessary

RB 8-5-21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

RB 8-5-21

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08-05-22 ①

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASS'Y, CABIN SLIDING DOOR

Job Number: 39362

Part Number: D3779043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D32031

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle

batch: B30158A

08/05/23

7.0

MS20426AD10 18

Rivet Countersunk



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) 0.5625" Long

Rivet Countersunk

batch: M108110

08/05/23

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- counter sink holes as per dwg D3779

2- deburr

3- rivet D3203-1 handle to D3779-5 plate as per dwg D3779

08/05/23

9.0

QC5

INSPECT WORK TO CURRENT STEP



ASS ENGINEERING APPROVAL



PC

Comment: INSPECT WORK TO CURRENT STEP

08/05/23 (1)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and stock

Location:

08/05/23 (1) ship David Shepard

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/27

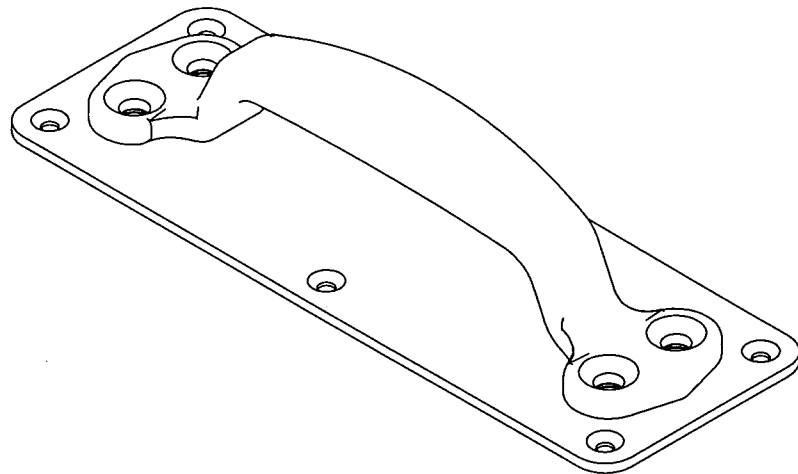
Job Completion



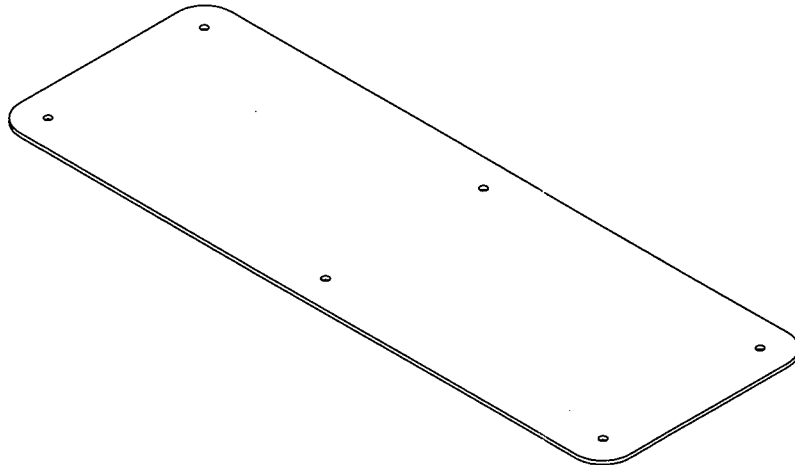
charge to w/o #00220A  
MF 08-05-23



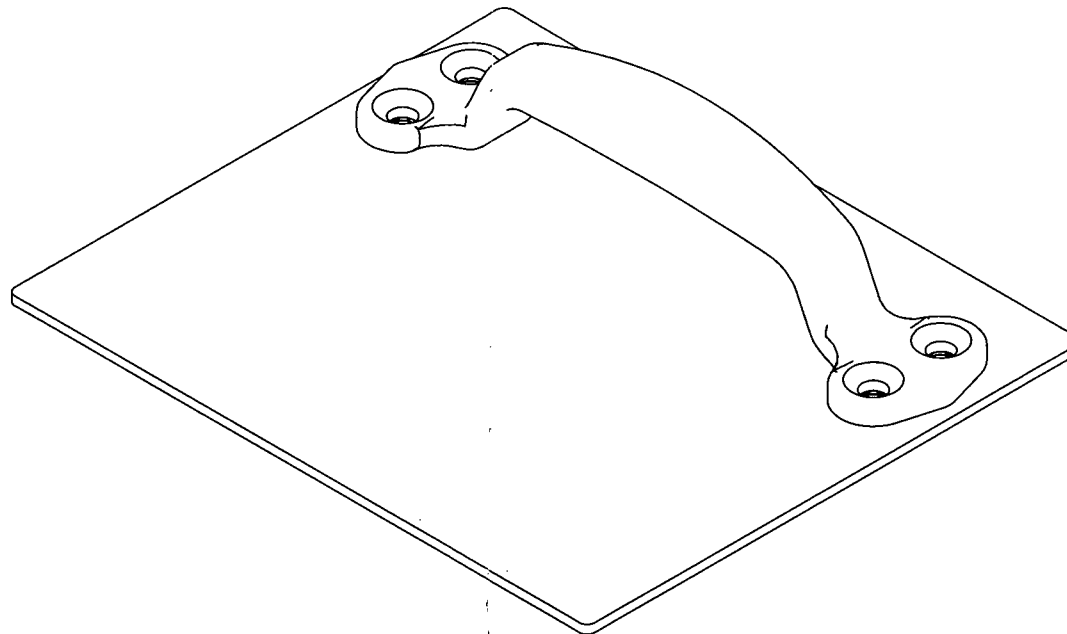
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-18	RIVET, CSK



**D3779-041 HANDLE ASSEMBLY**  
(EXTERIOR)



**D3779-3 PLATE**

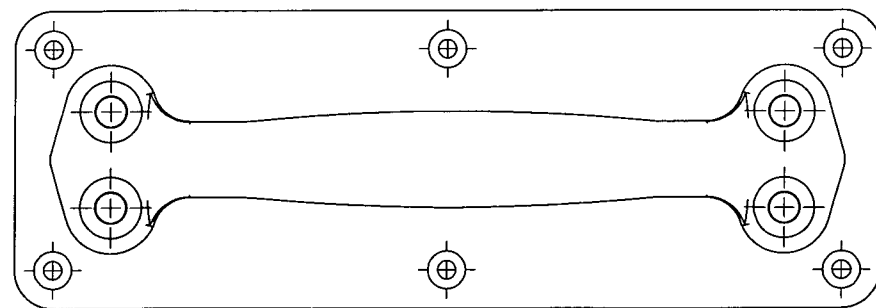


**D3779-043 HANDLE ASSEMBLY**  
(INTERIOR)

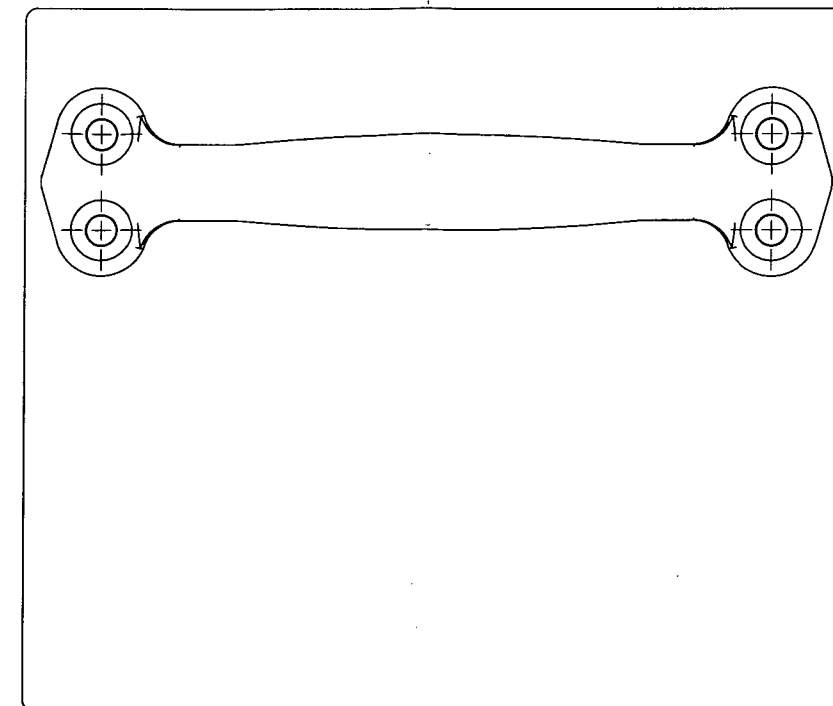
**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
AJS 08.0520

A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3779</b> REV. A SHEET 1 OF 3 TITLE <b>HANDLE ASSEMBLY, CABIN SLIDING DOOR</b> SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.04.21		

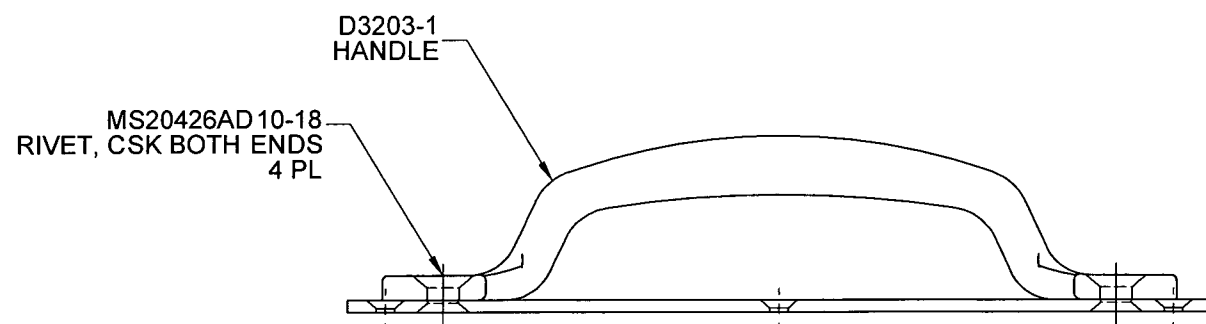




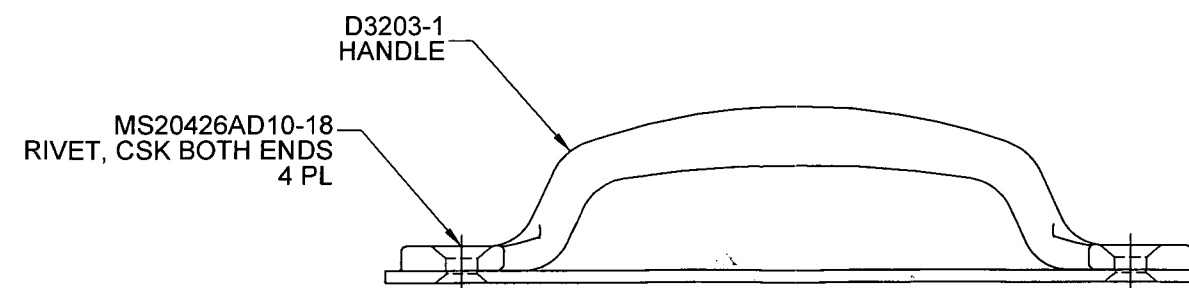
D3779-1  
PLATE



D3779-5  
PLATE



**D3779-041 HANDLE ASSEMBLY**  
(EXTERIOR)



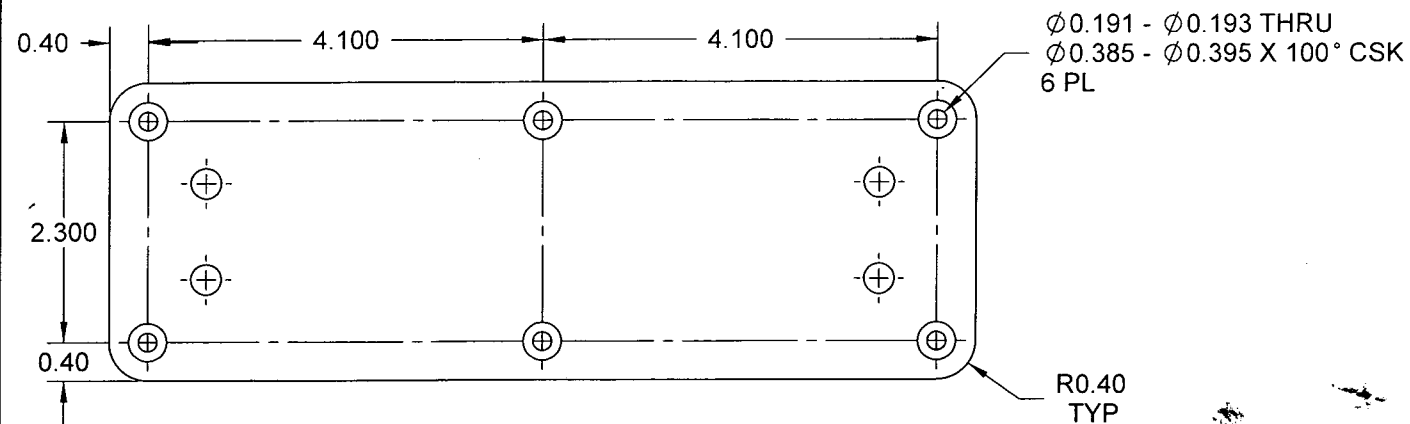
**D3779-043 HANDLE ASSEMBLY**  
(INTERIOR)

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
*AS 08.05.20*

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: PRIME PER DART QSI 005 4.2
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
  - 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
  - 8) WEIGHT: 1.50 lbs APPROX (-041)
  - 9) WEIGHT: 1.85 lbs APPROX (-043)

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3779</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>HANDLE ASSEMBLY,</b>	NTS
DATE	08.04.21	<b>CABIN SLIDING DOOR</b> <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

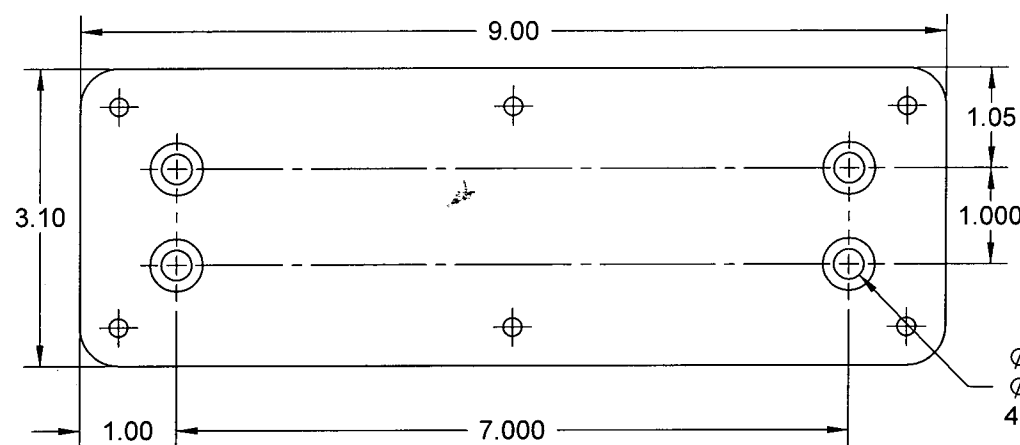




$\phi 0.191 - \phi 0.193$  THRU  
 $\phi 0.385 - \phi 0.395 \times 100^\circ$  CSK  
 6 PL

R0.40  
 TYP

0.125  
 REF



$\phi 0.316 - \phi 0.322$  THRU  
 $\phi 0.545 - \phi 0.555 \times 100^\circ$  CSK  
 4 PL

**D3779-1 PLATE**

**NOTES:**

1) MATERIAL: -1 & -5 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
 (REF DART SPEC M6061T6S.125)

-3 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
 (REF DART SPEC M6061T6S.050)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

PRIME PER DART QSI 005 4.2 -3 ONLY  
 (-1 & -5 TO BE PRIMED ON ASSEMBLY)

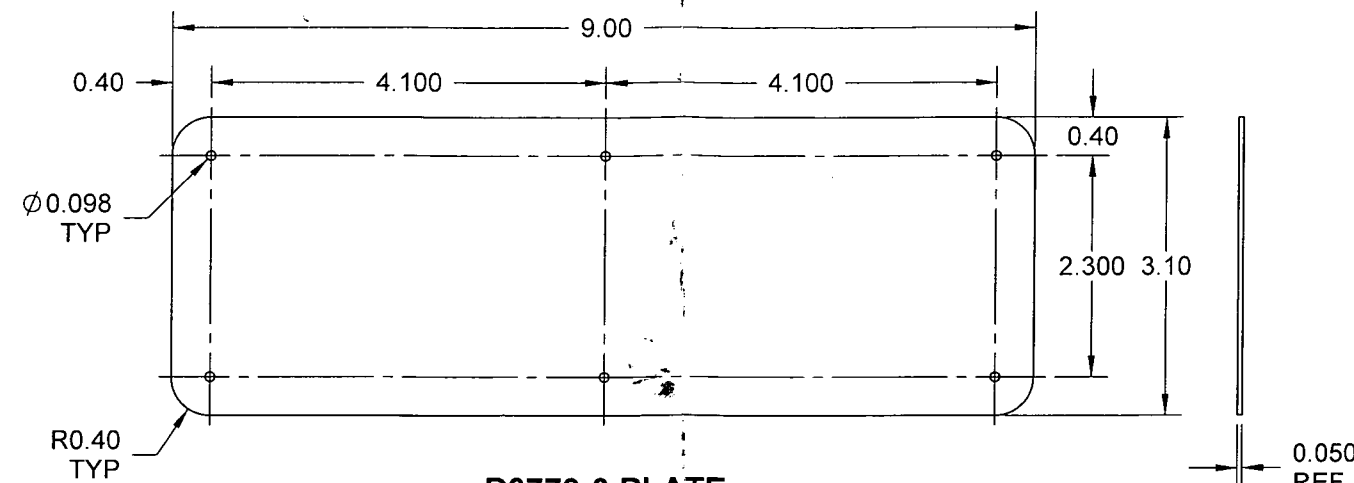
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

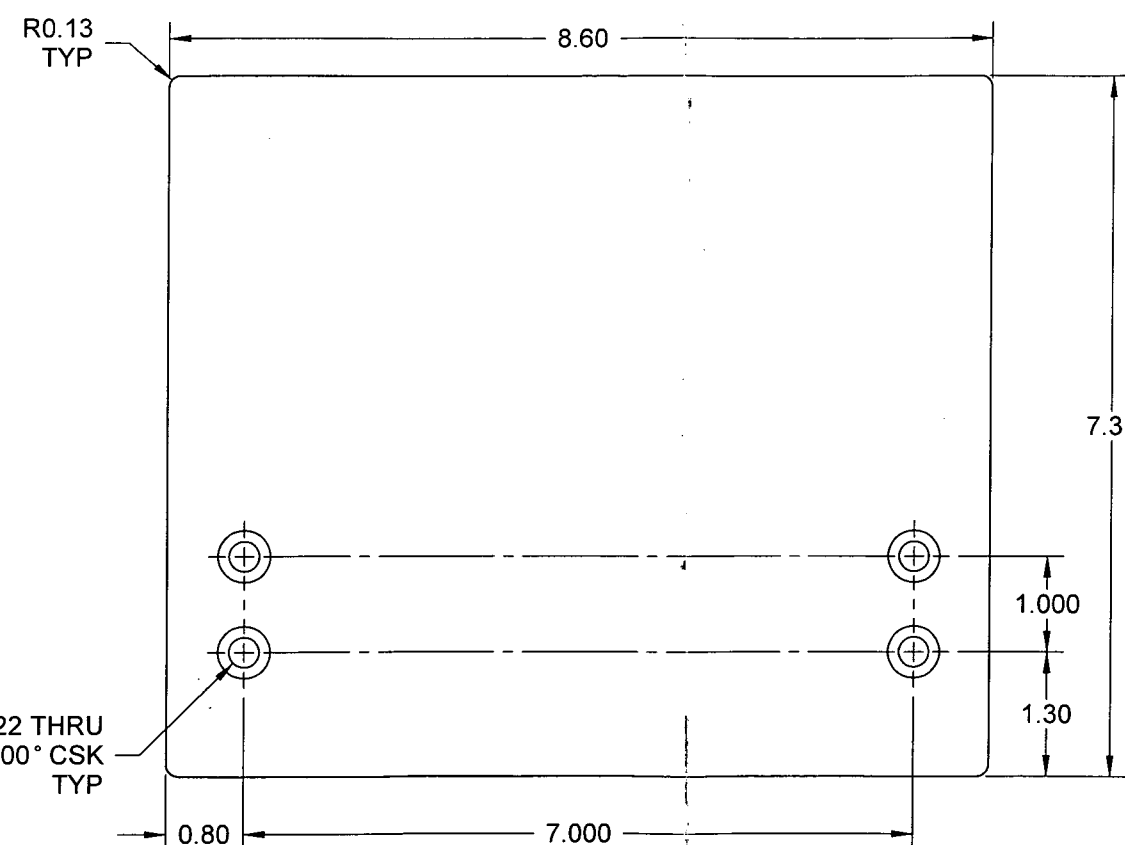
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER  
 IDENTIFY WITH DART P/N "D3779-5" USING FINE POINT PERMANENT INK MARKER  
 (DO NOT IDENTIFY -1)

7) WEIGHT: 0.13 lbs FOR -3.



**D3779-3 PLATE**



**D3779-5 PLATE**

**PROTOTYPE**  
 PLEASE RETURN ALL ISSUED  
 DATA TO ENGINEERING  
 153 08.05.20

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3779</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>HANDLE ASSEMBLY, CABIN SLIDING DOOR</b>	NTS
DATE	<b>08.04.21</b>	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-698

Job #: 00220

Date: 20-May-08

Product Name: Cabin Door Roller Kit (Comp Door)

Requested By: AJS

Design Manager Approval: 

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3779-043	Handle Assembly	20-May-08	No	27-May-08	Alodine and finish not required.	



